

In the Claims

Please amend the claims as follows:

- 1 1. (currently amended) A head stack assembly (HSA) for use in a disk drive comprising a
2 disk, wherein a merge tool is used to merge the HSA with the disk during manufacturing
3 of the disk drive, the HSA comprising:
4 (a) at least one actuator arm;
5 (b) a suspension connected to a distal end of the actuator arm;
6 (c) a head connected to a distal end of the suspension, ~~wherein the suspension for biasing~~
7 ~~the head toward the disk; and~~
8 (d) a multi-level shipping comb attached to the actuator arm, the multi-level shipping
9 comb comprising at least one finger ~~for maintaining the suspension in a near optimal~~
10 ~~vertical position~~ that limits relative vertical motion of the suspension, wherein:
11 the finger comprises a first surface and a second surface, wherein the second surface
12 is raised relative to the first surface;
13 during shipping of the HSA, the first surface of the finger contacts the suspension to
14 protect against overstressing the suspension; and
15 during manufacture of the disk drive, the shipping comb is actuated so that the second
16 surface contacts the suspension thereby bending the suspension in a vertical
17 direction to facilitate the insertion of the merge tool.
- 1 2. (original) The HSA as recited in claim 1, wherein:
2 (a) the actuator arm comprises an aperture; and
3 (b) the shipping comb comprises a pin and a latching member, wherein the shipping
4 comb is attached to the actuator arm by:
5 inserting the pin through the aperture of the actuator arm; and

6 rotating the shipping comb in a first direction until the latching member latches onto
7 the side of the actuator arm and the first surface of the finger contacts the
8 suspension.

1 3. (original)The HSA as recited in claim 2, wherein the shipping comb is actuated by
2 rotating the shipping comb so that the second surface contacts the suspension thereby
3 bending the suspension in a vertical direction to facilitate the insertion of the merge tool.

1 4. (original)The HSA as recited in claim 3, wherein the shipping comb is actuated by
2 rotating the shipping comb in the first direction.

1 5. (original)The HSA as recited in claim 3, wherein the shipping comb is actuated by
2 rotating the shipping comb in a second direction opposite the first direction.

1 6. (original)The HSA as recited in claim 1, wherein:
2 (a) the second surface comprises a beveled surface with respect to the first surface; and
3 (b) the suspension slides over the beveled surface when the shipping comb is actuated.

1 7. (original)The HSA as recited in claim 2, wherein after the merge tool is inserted, the
2 shipping comb is detached from the actuator arm by rotating the shipping comb in a
3 second direction opposite the first direction.

1 8. (original)The HSA as recited in claim 1, wherein after the merge tool is inserted, the
2 shipping comb is detached from the actuator arm causing the suspension to retract
3 vertically and engage the merge tool.

9. (original)The HSA as recited in claim 1, wherein the suspension comprises a coating for contacting the first and second surfaces of the finger to reduce friction between the finger and the suspension.

10. (original)The HSA as recited in claim 1, wherein:

(a) the finger of the shipping comb comprises an arcuate shape such that the first and second surfaces comprise an arcuate shape; and

(b) the second surface comprises a radius larger than a radius of the first surface.

11. (currently amended) A method of manufacturing a disk drive comprising a base casting, a disk, and a head stack assembly (HSA), the HSA comprising at least one actuator arm, a suspension connected to a distal end of the actuator arm, a head connected to a distal end of the suspension, ~~wherein the suspension for biasing the head toward the disk, and a shipping comb attached to the actuator arm for maintaining the suspension in a near optimal vertical position~~that limits relative vertical motion of the suspension, the method comprising the steps of:

(a) inserting the HSA into the base casting;

(b) actuating the shipping comb to bend the suspension in a vertical direction to facilitate the insertion of a merge tool comprising a finger for engaging the suspension;

(c) inserting the merge tool such that the finger of the merge tool moves into position without scraping against the suspension;

(d) detaching the shipping comb from the actuator arm wherein the suspension retracts vertically and engages the finger of the merge tool; and

(e) actuating the merge tool to merge the HSA with the disk.

1 12. (original)The method as recited in claim 11, wherein the shipping comb is actuated by
2 rotating the shipping comb to bend the suspension in a vertical direction to facilitate the
3 insertion of the merge tool.

1 13. (original)The method as recited in claim 11, wherein:
2 (a) the shipping comb comprises a beveled surface; and
3 (b) the suspension slides over the beveled surface when the shipping comb is actuated.

1 14. (original)The method as recited in claim 11, wherein the shipping comb is detached from
2 the actuator arm by rotating the shipping comb.

1 15. (original)The method as recited in claim 11, wherein the suspension comprises a coating
2 for reducing friction between the shipping comb and the suspension.